

# Lupox® TE5000GH

Polycarbonate + PBT

LG Chem Ltd.

## Message:

Description

High Impact, Dimensional Stability

Applications

Automotive(Door Garnish)

| General Information                              |                                 |                   |             |
|--------------------------------------------------|---------------------------------|-------------------|-------------|
| Features                                         | Good dimensional stability      |                   |             |
|                                                  | Impact resistance, high         |                   |             |
| Uses                                             | Application in Automobile Field |                   |             |
| Processing Method                                | Injection molding               |                   |             |
| Physical                                         | Nominal Value                   | Unit              | Test Method |
| Specific Gravity                                 | 1.21                            | g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (250°C/5.0 kg)         | 12                              | g/10 min          | ASTM D1238  |
| Molding Shrinkage - Flow (3.20 mm)               | 0.70 - 0.80                     | %                 | ASTM D955   |
| Water Absorption (Saturation, 23°C)              | 0.080                           | %                 | ASTM D570   |
| Mechanical                                       | Nominal Value                   | Unit              | Test Method |
| Tensile Strength <sup>1</sup> (Yield, 3.20 mm)   | 56.9                            | MPa               | ASTM D638   |
| Tensile Elongation <sup>2</sup> (Break, 3.20 mm) | > 100                           | %                 | ASTM D638   |
| Flexural Modulus <sup>3</sup> (6.40 mm)          | 1960                            | MPa               | ASTM D790   |
| Flexural Strength <sup>4</sup> (Yield, 6.40 mm)  | 88.3                            | MPa               | ASTM D790   |
| Impact                                           | Nominal Value                   | Unit              | Test Method |
| Notched Izod Impact                              |                                 |                   | ASTM D256   |
| -30°C, 3.20 mm                                   | 200                             | J/m               | ASTM D256   |
| 23°C, 3.20 mm                                    | 980                             | J/m               | ASTM D256   |
| Thermal                                          | Nominal Value                   | Unit              | Test Method |
| Deflection Temperature Under Load                |                                 |                   | ASTM D648   |
| 0.45 MPa, unannealed, 6.40mm                     | 115                             | °C                | ASTM D648   |
| 1.8 MPa, unannealed, 6.40mm                      | 100                             | °C                | ASTM D648   |
| Peak Melting Temperature                         | 223                             | °C                | ASTM D3418  |
| Injection                                        | Nominal Value                   | Unit              |             |
| Drying Temperature                               | 120                             | °C                |             |
| Drying Time                                      | 4.0 - 5.0                       | hr                |             |
| Suggested Max Moisture                           | 0.020                           | %                 |             |
| Rear Temperature                                 | 250 - 260                       | °C                |             |
| Middle Temperature                               | 250 - 260                       | °C                |             |
| Front Temperature                                | 255 - 265                       | °C                |             |

|                        |             |    |
|------------------------|-------------|----|
| Nozzle Temperature     | 260 - 270   | °C |
| Processing (Melt) Temp | 260 - 270   | °C |
| Mold Temperature       | 60.0 - 80.0 | °C |

#### Injection instructions

Minimum Moisture Content: 0.02%

#### NOTE

|    |            |
|----|------------|
| 1. | 50 mm/min  |
| 2. | 50 mm/min  |
| 3. | 5.0 mm/min |
| 4. | 5.0 mm/min |

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